

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011511**Date Inspected:** 07-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Components				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

OUTSIDE SHOP

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as Segment 7DW. The weld designations reviewed are as follows:

SEG039*-007,009,010,038,017.

SSD11-PP57-003,004.

SSD12-PP58-004,005.

SSD11A-PP56-165.

SSD12A-PP58-165.

Segment 7DW Additional welding added the location where tight fit required is X74E Angle connecting longitudinal diaphragm in the bottom plate the weld location is identified as SSD22-PP56.5 to W4 And SSD22-PP57.5 to W4. The gap found more than 7mm instead of tight fit on that location so ZPMC put some small piece of plate on that location and done welding with stiffener to small piece of plate. Informed to ZPM QC Mr. Wang xian pin. See attached photos.

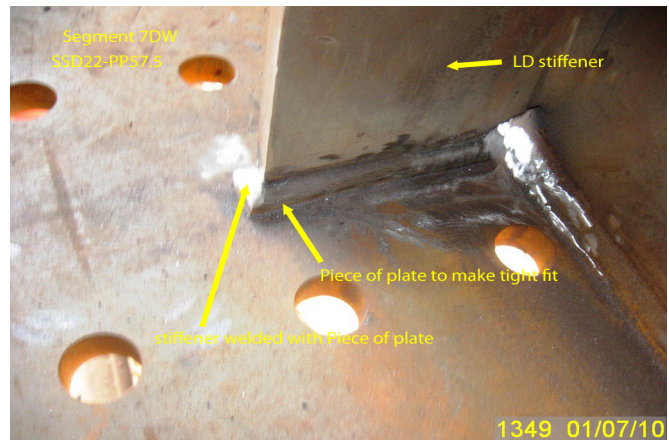
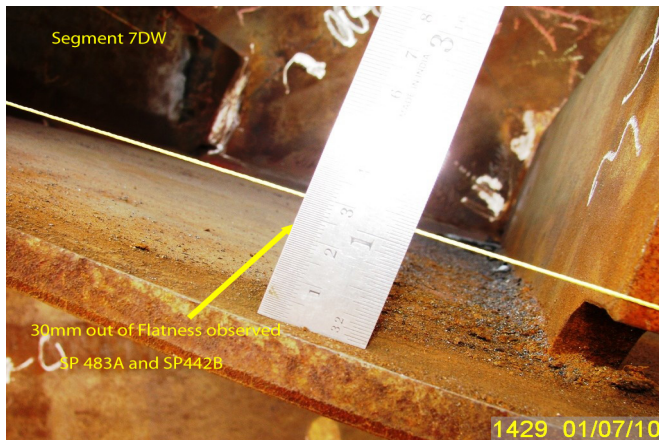
Segment 7DW Distortion found at the location of Side plate connecting to side plate , the plate is identified as SP483A to SP442B and the weld no is identified as SEG039A-024,25. So dimension measured with Caltrans

WELDING INSPECTION REPORT

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inspector Mr.Manikanadan 30mm max out of straightness observed and recorded sent to Engineer for further action. Informed to ZPMC QA Mr.Zhang wei.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer